

Date: Thursday, 11/8/2007 8:01:14 AM  
 User: Jean-Luc Menard

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CONSOLE TRIM ANGLE		
Job Number	: 35583		Part Number	: D2163		
Estimate Number	: 10228		Drawing Number	: D2163 REV. B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 11/8/2007 S.O. No. : N/A		Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: 11/6/2007		Due Date	: 12/20/2007 Qty: 40 Um: Each		
Previous Run	:					
Written By	: <u>JL</u> 07.11.08					
Checked & Approved By	:					
Comment	: EstF 02.05.11 Clarify IPP NG					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M5052H32S050	5052-H32 .050 Sheet  3.8637
Comment: Qty.: 0.0729 sf(s)/Unit Total : 2.9148 sf(s) Material: 5052-H32 (QQ-A-250/8) 0.050" thick (M5052H32S.050) Batch: 14050 1B 07-11-12		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D2163 Dwg Rev. <u>B</u> 1B 07-11-12 Prog Rev. <u>B</u> S3		
2-Deburr if necessary HB 07-11-12		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  1B 07-11-12
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK  JL 07-11-13 (S3) counted.
Comment: SECOND CHECK		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Form as per QSI 003 and Dwg D2163 <u>PS</u> 07/12/03 5/13 1B 07/12/03 (S3)		

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Drawing Name: CONSOLE TRIM ANGLE

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Seq. #: Machine Or Operation:

Description:

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 07/12/05 (53) coantes

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 07/12/05 (53)

8.0 POWDER COATING

POWDER COATING



M100700



(53X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

m-f 07/12/05

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(53)

Comment: INSPECT POWDER COAT

BL 07-12-05

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 18

7/12/06 SP

(53X)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12 07/12/06

Job Completion



CL 07-12-06

DART AEROSPACE LTD	Work Order:	35583
Description: Trim Angle	Part Number:	D2163
Inspection Dwg: D2163	Rev: B	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

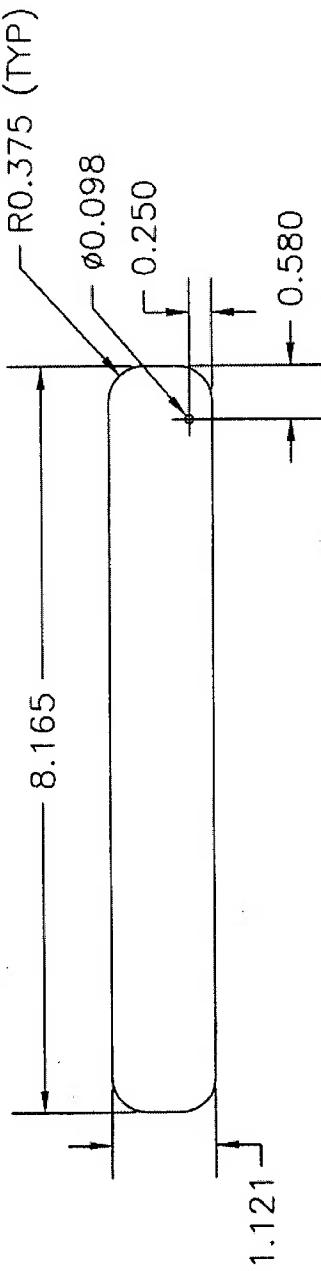
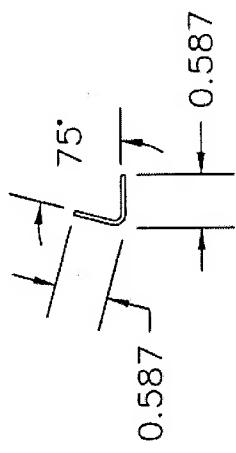
## X First Article      Prototype

Measured by: <u>RB</u>	Audited by: <u>/</u>	Prototype Approval: N/A
Date: <u>07-11-12</u>	Date: <u>07-11-13</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	05.05.10	New Issue	KJ/JLM	SJL

**DART**D COPY IS  
OPEN

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	APPROVED	DRAWING NO. REV. B D2163 SHEET 1 OF 1
DATE		TITLE SCALE
97.10.30		TRIM ANGLE 1:2
A	95.05.19	RE-DRAWN
B	97.10.30	REMOVE BEND DATA

**RELEASED**97.11.04 KE  
TSR A421

MATERIAL: 5052-H32 (QQ-A-250/8) 0.050 THICK  
 FINISH: POWER COAT MATTE BLACK PER DART QSI 005 4.3

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 35583